

Work Order ID 130871

March-26-15 1:25:53 PM

130871

Page 1

Item ID: D6201

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: "T" Extrusion

Stop ***NS2***

Start Date: 3/26/15 Start Qty: 12.00

12

20 ft
CL 15/04/02

Cust Item ID:

Required Date: 3/26/15 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: MCS

Date: 15-03-27 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D6201	Rev A

100

0.00

100

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 28001

CL 15/04/02 20

a)Description: T-beam extrusion

b) 4.00" x 4.00" x 0.375"

c) Minimum Ultimate Tensile Strength = 38ksi

d) Minimum Yield Tensile strength = 35ksi

e) Material: 6061-T6/T6511 (QQ-A-200/8)

f)Material certification required

EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.

MUST BE WELL PACKAGE, IF NOT IT WILL BE REFUSE

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 130871

130871

Page 2

March-26-15 1:25:53 PM

Item ID:	D6201	Accept	*N900040100*	Setup	Start	*NS1*
Revision ID:				Stop		*NS2*
Item Name:	"T" Extrusion					
Start Date:	3/26/15	Start Qty: 12.00	*12*	Cust Item ID:		
Required Date:	3/26/15	Req'd Qty: 12.00	*12*	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	Memo	0.00							
Packaging	Ensure material certification is attached								
120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control	Ensure Material certification comply to Dwg D6104								
130	Identify as per dwg & Stock Location:	0.00							
130									
Packaging	Memo	0.00							
Packaging									

201 8/15-04-13

02/15/05/14
return to vendor

ML3 MAY 14 2015
φ

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 130871***130871***

Page 3

Item ID: D6201

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: "T" Extrusion

Stop

NS2

Start Date: 3/26/15

Start Qty: 12.00

12

Cust Item ID:

Required Date: 3/26/15

Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

March-26-15 1:25:53 PM

Page 1

Work Order ID: 130871

130871

Parent Item: D6201

D6201

Parent Item Name: "T" Extrusion

Start Date: 3/26/15

Required Date: 3/26/15

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP A: 01.05.15New Issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6201P		Purchased	No			110	f	0.0000	1	12			
D6201P									**	20			
T Extrusion 4X4X3/8													

20 SP15-04-13.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

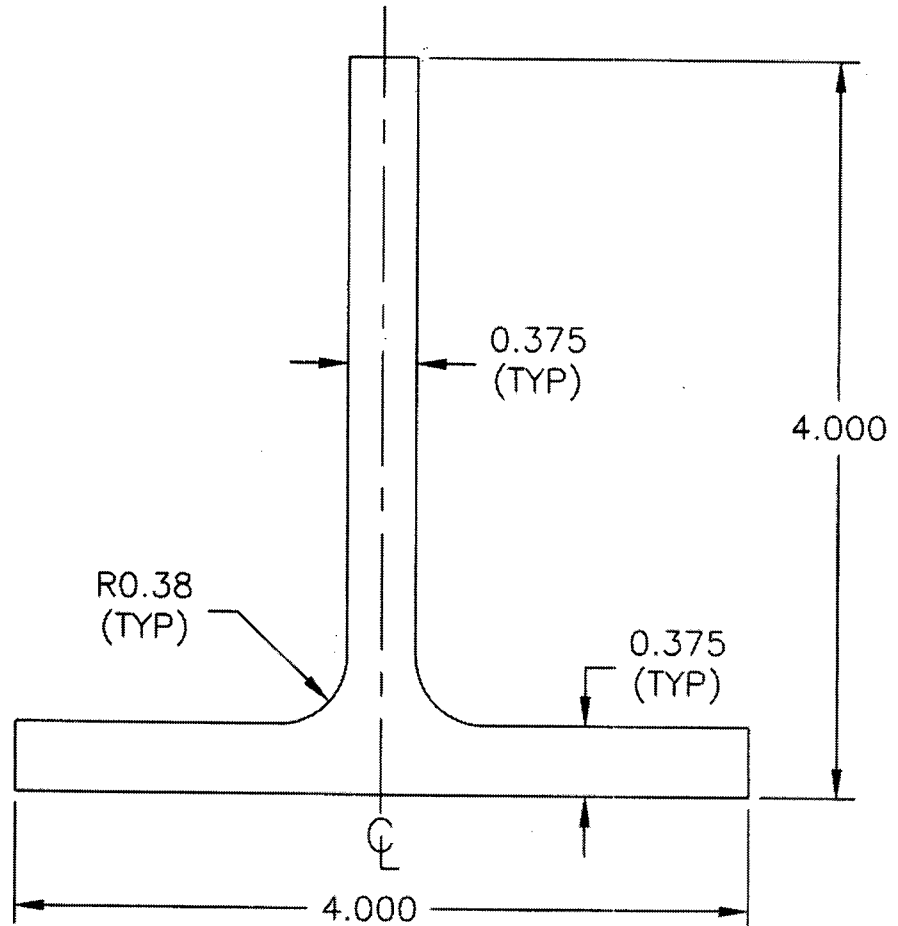
Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D6201	REV. A SHEET 1 OF 1
DATE 01.04.10		TITLE T-BEAM EXTRUSION	SCALE 1:1
A	01.04.10	NEW ISSUE	

SPECIFICATION CONTROL DRAWING

RELEASED
01.04.23 *[Signature]*



D6201-XXX T-BEAM EXTRUSION
WHERE XXX IS LENGTH IN INCHES

EG.
D6201-027 IS 27 INCHES LONG

PURCHASE MATERIAL: ALUMINUM "T"-EXTRUSION ROUND FILLET
4.000" x 4.000" x 0.375"

6061-T6/T6511 (QQ-A-200/8)

MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi

MINIMUM YIELD TENSILE STRENGTH = 35 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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130841 MCH
1503-27
SHIP COPY
RETURN TO
DART AEROSPACE LTD
HAWKESBURY, ONTARIO
CANADA



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO28001

Purchase Order Date 4/2/2015

PO Print Date 4/6/2015

Page Number 1 of 2

Order From :

VC-CAM002

Ship To : DART AEROSPACE LTD

CAMPI STEEL
935 BOUL. DU HAVRE
VALLEYFIELD, QC J6S 5L1
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

REVISED

Contact Name

Vendor Phone 800 667 4248

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Ship To Contact

Ship To Phone

Ship Via: Yours ppd

Ship Acct:

Terms

Net 30

Currency

CAD

FOB

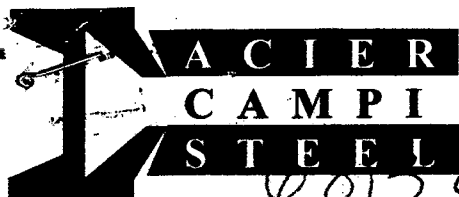
FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D6201P AS PER DWG D6201 REV. A B130871 T-BEAM EXTRUSION 4" X 4" X 0.375" MATERIAL: 6061-T6 AS PER QQ-A-200/8	T Extrusion 4X4X3/8	4/13/2015 Yes 4/13/2015		20.00 f	\$12.48	\$249.60
						Line Total:	\$249.60
2	71725-45 MILD STEEL ANGLE 2" X 2" X 1/8" WALL	MILD STEEL ANGLE 2" X 2" X 1/8" WALL	4/13/2015 Yes 4/13/2015		40.00 Each	\$1.07	\$42.80
						Line Total:	\$42.80
Deliver To: LUC/MUFFIN							
3	71550-10 303 ROUND BAR 5" DIA.	303 ROUND BAR 5" DIA.	4/13/2015 Yes 4/13/2015		3.00 Each	\$224.65	\$673.95

Note:

4/6/2015

Rec'd 12.
5/5-04-13



1993
DEPUIS - SINCE
Merci! - Thank you!

935, boul. du Havre
Valleyfield, Québec
J6S 5L1
Valleyfield
Tél.: 450 377-4248
Fax : 450 377-5696

Montréal
Tél.: 514 336-4248
Fax : 514 336-4246
Ontario
Tél.: 1 800 667-4248
Fax : 1 866 456-4242

www.aciercampi.com

VENDU À / SOLD TO :

613-632-5200 613-632-1053

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY,
ONTARIO
K6A 1K7

EQUIP: LIFT

EXPÉDIEZ À / SHIP TO :

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY,
ONTARIO
K6A 1K7

COMMANDE ORDER	N° 246011
DATE	06/04/15
BON DE LIVRAISON PACKING SLIP	N°
DATE DE LIVRAISON DELIVERY DATE	10/04/15

VOTRE N° DE COMMANDE / YOUR PO. N° P028001	VENDU/SALES M. U	CODE CLIENT / CUST. CODE DAER	EXPÉDIER PAR / SHIP VIA 12345	TERMES / TERMS NET 30 JOURS	TEBB 2F	REMARQUES / REMARKS	PAGE N° 001
---	---------------------	----------------------------------	----------------------------------	--------------------------------	------------	---------------------	----------------

CODE DE PRODUIT PRODUCT CODE	COMMANDE ORDERED	EXPÉDIE SHIPPED	DESCRIPTION	POIDS WEIGHT	PRIX PRICE	PAR PER	MONTANT AMOUNT
M	✓	1x36"	ROND SS-303 5" DIAM. 1 X 36"	1.00		✓	
M	✓	1x20"	EXTRUSION 4" X 4" X 3/8" ALUMINIUM 6061-T6 1 X 20" <i>Coffee tube</i>	1.00		✓	
A 2218	40 ✓	2x20'	ANGLE 2" X 2" X 1/8" 20' <i>Spisou-B</i>	66.00		✓	
						✓	
						✓	
						✓	
						✓	

Unités de mesure : CLB Carr (100) livres / Hundred pounds CPI Carr (100) pieds / Hundred feet UN Unit / Unit PI Pieds / Feet PC Pied carré / Square foot

POIDS TOTAL 68
TOTAL WEIGHT

CONDITIONS :
LES MATÉRIAUX LIVRÉS ET FACTURÉS TELS QUE DÉCRITS DEMEURENT LA PROPRIÉTÉ DE "ACIER CAMPI INC." JUSQU'À PAIEMENT COMPLET EN CASH. • LES RISQUES DE PERTE DU BIEN SONT À LA CHARGE DE L'ACHETEUR. • LA GARANTIE DE QUALITÉ DU MATÉRIEL EST LA MÊME QUE CELLE DU FABRICANT. • L'ACHETEUR S'ENGAGE À RESPECTER LES CONDITIONS SUIVANTES : NET 30 JOURS DE LA DATE DE FACTURATION, ET TOUT COMPTE IMPAYÉ DANS LES 30 JOURS ENTRAÎNE DES FRAIS DE 2% PAR MOIS (24% PAR ANNÉE) QU'IL ACCEPTE DE PAYER. • TOUT DÉFAUT D'EXÉCUTION L'UNE OU L'AUTRE DES OBLIGATIONS EN VERTU DU PRÉSENT CONTRAT ENTRAÎNE LA DÉCHÉANCE DU TERME ET PERMET AU VENDEUR, À SON CHOIX, DE RÉCLAMER TOUT SOLDE DU PRIX DE VENTE OU REPRISE LE BIEN VENDU. • TOUTE RÉCLAMATION DOIT ÊTRE FAITE DANS LES CINQ JOURS SUR PRÉSENTATION DE CE DOCUMENT. • TOUTE MARCHANDISE ENDOMMAGÉE, ALTÉRÉE OU COUPÉE NE PEUT ÊTRE REPRISE. • AUCUN RETOUR DE MARCHANDISE NE SERA ACCEPTÉ SANS NOTRE AUTORISATION. • TOUTE MARCHANDISE RETOURNÉE EST SUJETTE À DES FRAIS DE MANUTENTION DE 25%.

CONDITIONS :
ALL SOLD AND DELIVERED MATERIALS REMAIN THE PROPERTY OF "ACIER CAMPI INC." UNTIL PAYMENT IS MADE FULL, COMPLETE AND CASHED. • ALL LOST MATERIALS ARE AT THE BUYER'S EXPENSE. • ALL MATERIALS BEAR THE SAME WARRANTY AS GIVEN BY THE MANUFACTURER. • THE BUYER HEREBY ACCEPTS TO RESPECT THE FOLLOWING CONDITIONS: NET 30 DAYS FROM BILLING DATE AND THE BUYER ACCEPTS TO PAY ADMINISTRATION CHARGES OF 2% PER MONTH OR 24% PER ANNUM ON ALL PAST DUE ACCOUNTS OVER 30 DAYS. • ANY DEFAULT IN RESPECT WITH THIS CONTRACT WILL LEAD TO PAYMENT BY ACCELERATION AND PERMITS TO THE SELLER, AT HIS CHOICE TO CLAIM FOR THE BALANCE DUE OR THE REPOSSESSION OF THE GOODS SOLD. • ANY CLAIM MUST BE MADE WITHIN FIVE DAYS WITH THIS DOCUMENT ENCLOSED. • ANY MERCHANDISE THAT HAS BEEN DAMAGED, CUT OR MODIFIED CANNOT BE RETURNED. • ALL GOODS RETURNED MUST BE WITH OUR AUTHORIZATION AND ARE SUBJECT TO A 25% RESTOCKING CHARGE.

SOUS-TOTAL SUB TOTAL
T.P.S. G.S.T.
T.V.Q. / T.V.H. G.S.T. / H.S.T.
TOTAL

PRÉPARÉ PAR / PREPARED BY <i>UHL/fig</i>	VÉRIFIÉ PAR / VERIFIED BY <i>UHL</i>	LIVRÉ PAR / DELIVERED BY <i>UHL</i>	HEURE / TIME
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MARCHANDISE REÇUE EN BONNE CONDITION MERCHANDISE RECEIVED IN GOOD CONDITION	A/Y M/M J/D <i>156 4/10</i>
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Supplier Non-Conformance Report

Reviewed			
DQA:			
Date:			
Printed on: Friday, April 17, 2015			
Details			
Raised Date 4/17/2015	Status Open	Owner Lacelle, Linda	Number NCR15-4816
Target Date 5/5/2015	Standard	Severity	
Process Quality Inspection		Audit	
Raised By Person Downing, Eric M	Raised Against (Department or Supplier) Campi Steel	Fault Category Supplier	
Details found durring inspection that D6201 "T" extrusion is not to drawing. the material has tapers on the vertical and horizontal and the incorrect rad PO#28001 B130871vertical goes from 0.380" to 0.425" should be 0.375"horizontal goes from 0.380 to 0.420" should be 0.375" rad size is not 0.375" also th eheat # to trace packaging slip to cert is missing			
Keywords		Product D205-523\D6201	
Document		Root Cause 4	
Closed By	Closed Date	Resolution	

Corrective Action			
Target Date 5/4/2015	Owner Downing, Eric M	Closed Date	Closed By
Details			

Actions			
Number	Owner	Target Date	Completed Date
Details		Response	
1	Downing, Eric M	4/24/2015	
contact supplier of issue and request corrective action			
2	Downing, Eric M	5/1/2015	
keep material length in quarantine till response is received from supplier			

Verification & Review				
Target Date 5/4/2015	Owner Downing, Eric M	Closed Date	Closed By	
Details				

Actions				
Number	Owner	Target Date	Completed Date	
Details		Response		



Service Center Metals
5850 Quality Way
Prince George, VA 23875

CERTIFIED INSPECTION REPORT AND TEST RESULTS FOR EXTRUDED PRODUCTS

After Comp

OUR ORDER NUMBER 227194	ITEM 1
CERTIFICATION ASTM-B308-10 SPOT STENCIL	
SPECIFICATION ASTM-B221-'4	
SPECIFICATION AMS-QQA-200/8 - 1997	

BILL TO	HARVEST NUMBER 254195	ID# NUMBER T0568	DATE OF SHIPMENT 3/13/2015
SHIP TO	CUSTOMER PO B776023	ALLOY/TEMPER 6061-T6	SALESPERSON D.Schroeder (Canada)
Quantity Certified 1,048 lbs	14pcs	CUSTOMER PART NUMBER T0568X20 FT	DESCRIPTION AST 4.000x4.000x.375

We hereby certify that the material covered by this report has been inspected in accordance with the most recent certification revision, and has been found to meet the applicable requirements described herein, including any specifications forming a part of the description, and that samples representative of the material met the composition limits and had the mechanical properties shown. SCM extrusions are manufactured in the USA.

Mechanical Properties

Tests	Lot No.	Test Date	Ultimate Tensile Strength (KSI)		Yield Strength (KSI)		Percent Elongation	
4	201503894	3/3/15	min	max	min	max	min	max
			44.00	47.00	40.40	43.80	15.53	17.52

Chemical Composition for Aluminum Alloy 6061

Cast#	Lot No.	Alloy	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Al	Others Each	Total	Melt Source
4M150111F	201503894	6061	0.67	0.35	0.23	0.08	0.97	0.08	0.03	0.02	97.57	0.05	0.15	United States of America

Print Date: 3/13/2015

Calvin J. Wiggins
Calvin J. Wiggins, Director of Quality & Technical Services

Rev. 9/23/11 - UHS

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D6201
 DATE: 15/04/13

PO / BATCH NO: 28601/130871

MATERIAL CERT REC'D: NO
 QUANTITY RECEIVED: 20'
 QUANTITY INSPECTED: 20'
 QUANTITY REJECTED: _____

THICKNESS ORDERED: 4.00 X 4.00 X .375
 THICKNESS RECEIVED: check comment
 SHEET SIZE ORDERED: _____
 SHEET SIZE RECEIVED: _____

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y ☒ N ☐	
CORRECT FINISH	☒ Y ☐ N	
CORROSION	Y ☐ N ☒	
CORRECT GRAIN DIRECTION	☒ Y ☐ N	
CORRECT MATERIAL	Y ☐ N ☒	
CORRECT THICKNESS	Y ☐ N ☒	
PHOTO REQUIRED	Y ☐ N ☒	
CORRECT MATERIAL	Y ☐ N ☒	
CORRECT REF # TO LINK CERT	Y ☐ N ☐	
CORRECT MATERIAL IDENTIFICATION	Y ☐ N ☐	
CORRECT M# ON THE MATERIAL	Y ☐ N ☐	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y ☐ N ☐	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y ☐ N ☐	

CUT SAMPLE PIECE OF MATERIAL AND PERFORM A HARDNESS CHECK. RECORD RESULTS BELOW				
TYPE OF MATERIAL SIZE OF TEST SAMPLE HARDNESS / DUROMETER READING	HRC	HRB	DUR A	DUR D

testers located in the Quality Office

QC 18 INSPECTION	ENGINEERING SIGNOFF (if required)
INSPECTED BY: _____	SIGNED OFF BY: _____
DATE: _____	DATE: _____

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

MATERIAL RECEIPT INSPECTION FORM

INSTRUCTIONS FOR INSPECTING BAR, TUBING, ROUND, & SHEET STOCK

- 1- VERIFY STOCK TO DART PURCHASE ORDER
- 2- MEASURE ALL DIMENSIONS FOR EACH PURCHASED STOCK
 - a. WIDTH, THICKNESS, DIAMETER, WALL THICKNESS & LENGTH
- 3- VERIFY CONDITION OF MATERIAL i.e. DAMAGED, CORRODED, etc.
- 4- VERIFY THAT SUPPLIER HAS A NUMBER (HEAT #) ON ITS RECEIVING REPORT TO LINK TO MATERIAL CERTS
- 5- VERIFY MATERIAL CERTS ARE CORRECT TO THE DART PO INSTRUCTIONS
- 6- REMOVE / CUT A PIECE OF MATERIAL FOR SAMPLE HARDNESS TESTING

INSTRUCTIONS FOR INSPECTING SKIDTUBE & STEP EXTRUSION

- 1- VERIFY TO DART SUPPLIED DRAWING
- 2- SAMPLE INSPECT MATERIAL IN BUNDLE TO ENSURE MATERIAL CAN BE RECEIVED INTO DART
- 3- USING PORTABLE HARDNESS TESTER VERIFY HARDNESS OF THE MATERIAL TO THE DRAWING
- 4- VERIFY THAT MATERIAL CERTS MATCH TO WHATS CALLED UP ON THE DART DRAWING

AFTER MATERIAL PASSES INSPECTION

- 5- HAVE DART EMPLOYEES START STOCKING MATERIAL BUT REQUEST MIN **20pcs** FOR FULL INSPECTION
- 6- INSPECT ALL DIMS AS PER DRAWING REQUIREMENTS

INSTRUCTIONS FOR INSPECTING CROSS TUBE MATERIAL

- 1- VERIFY MATERIAL CERTS MATCH THE REQUIREMENTS ON THE DART DRAWINGS
- 2- INSPECT MIN. HALF THE BATCH OF EXTRUSION RECEIVED INTO DART
- 3- INSPECT MATERIAL AS PER THE EXTRUSION REPORT
 - a. WALL THICKNESS USING ULTRA-SONIC IN 4 LOCATIONS
 - b. OUTSIDE DIAMETER HIGHEST/LOWEST BOTH ENDS
 - c. INSIDE DIAMETER HIGHEST/LOWEST BOTH ENDS
 - d. STRAIGHTNESS @ CENTER OVER 12" SPAN
 - e. WALL THICKNESS USING TUBE MICROMETER HIGHEST/LOWEST BOTH ENDS
- 4- IDENTIFY EACH TUBE IN SEQUENCE OF INSPECTING (TUBE 1, TUBE2.....) AND W/O# AND PO#
- 5- RECORD ALL FINDINGS ON EXTRUSION REPORT

IF ANY QUESTIONS PLEASE SEE QC COORDINATOR BEFORE GOING FURTHER